

Date: Wednesday, 4/5/2006 8:07:11 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 1/4 TURN FASTNER RAIL (BLACK)		
Job Number	: 26486		Part Number	: D103858B		
Estimate Number	: 10096		Drawing Number	: D1038		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 4/5/2006	S.O. No. : N/A	Drawing Revision	: B		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: 4/4/2006	Type : MACHINED PARTS	Due Date	: 4/21/2006	Qty:	80
Previous Run	: N/A		Um:	Each		
Written By	: <u>Seq 1 comment below</u>					
Checked & Approved By	: <u>06.04.04</u>					
Comment	: Est: E 03.05.02 Reformat; Added label		KJ/RF			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL  
<b>Comment:</b> DOCUMENT CONTROL Create white labels and bag them		
2.0	D2023	Extrusion, Fastener Rail  
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 80.0000 Each(s) Extrusion, Fastener Rail Batch: <u>21907</u> <span style="float: right;">J.F. 06/04/19 80</span>		
3.0	BAND SAW	BAND SAW  
<b>Comment:</b> BAND SAW Cut extrusion D2023 to length 21.81" (+0.06/-0.00) <span style="float: right;">J.F. 06/04/19 80</span>		
4.0	HAAS	HAAS CNC VERTICAL MACHINING #1  
<b>Comment:</b> HAAS CNC VERTICAL MACHINING #1 1-Machine as per Folio and Dwg D1038-58 <span style="float: right;">J.F. 06/04/20 80</span>		
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE  
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE <span style="float: right;">J.F. 06/04/20 80</span>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 QC8 SECOND CHECK



Comment: SECOND CHECK

MS 06104121 80

7.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

FF 06-05-01

80

8.0 OUTSIDE SERVICE OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: P.O 1138

Black Anodize as per Dwg D1038

Loc 105102 80

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Loc 110 80

10.0 QC3 INSPECT POWDER COAT/ CHEMICAL CONVERSION



Comment: Inspect Anodize. Place in foam to protect anodize

11.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Stake .050 stainless steel wire per Dwg D1038-58 using DT8389

Batch: M4050

2-Grind wire flush and deburr

3-Clean

540 06-05-14 80

12.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Loc 06-05-16 79

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-05-02	7.0	Add Q6.5 permanent change. <i>2</i>  Inspect QCS					<i>2</i>
06-05-11	8.0 10.0	Anodize to mill spec Mil-A8625F1 Type II Class 2 Add to steps 8 & 10. Mill spec should be written on the drawing for P/I & inspection.  permanent change. <i>2</i>		06-05-02	u		<i>2</i> 06-05-11

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA: *2* Date: 06/05/16 <sup>79</sup>  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-05-16	11	Part scrup. <del>the</del> end punched too hard and bent the corner, bad damaged the most!!	<i>2</i> <i>06-05-16</i>	Scrap & destroy	SAD 06-05-16	<i>2</i> 06-05-16	<i>2</i> <i>06-05-16</i>	<i>2</i> 06-05-16

NOTE: Date & initial all entries

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Part Number: D103858B

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

1-Pack each fastener rail into a cardboard tube

2-Taper ends to close cardboard tubes

3-Apply white labels to cardboard tubes

4-Identify and Stock

Location: FG47



05.06.16



14.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21



Job Completion



W 06-05-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	
<b>Description:</b> 1/4" Turn Fastener	<b>Part Number:</b>	<b>D1038-58B</b>
<b>Inspection Dwg:</b> D1038-58B <b>Rev:</b> B		<b>Page 1 of 1</b>

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	<u>JYL</u>	Audited by:	<u>ES</u>	Prototype Approval:	N/A
Date:	06/04/20	Date:	06/04/20	Date:	N/A

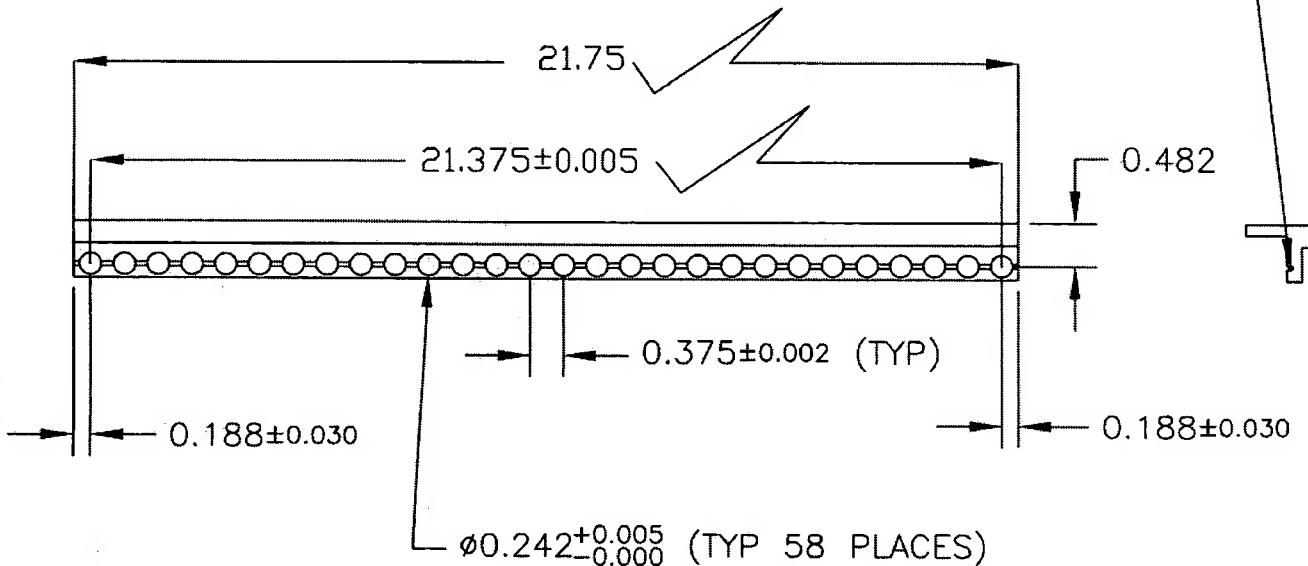
Rev	Date	Change	Revised by	Approved
A	05.02.16	New Issue	KJ/JLM	
B	06.03.08	21.750 was 12.750, Dwg rev. changed	KJ/JLM	

**DART**

DESIGN #4	DRAWN BY JL	<b>DART AEROSPACE LTD</b>	
CHECKED SAC	APPROVED JL	HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D1038		REV. B	SHEET 1 OF 1
DATE 05.02.02	TITLE 1/4 TURN FASTENER RAIL	SCALE NTS	
A 04.05.14 UPDATE TOLERANCE			
B 05.02.02 REDRAWN, UPDATE NOTES			

RELEASED  
05.03.31

STAKE Ø0.50 TYPE 302 STAINLESS  
STEEL WIRE FULL LENGTH  
(REF DART SPEC M302SW.050)



D1038-58 1/4 TURN FASTENER RAIL

- 1) MAKE FROM D2023 EXTRUSION
- 2) FINISH: D1038-58 - NONE  
D1038-58B - ANODIZE BLACK PER DART QSI 017 4.1.10
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER NO. 2648.6

SHOP COPY  
RETURN TO  
ENGINEERING

**TNM****ANODISATION et PEINTURE TNM INC.****C. OF C**

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2  
Telephone: (514) 429-7777 Fax: (514) 429-5108  
Certifié ISO 9001-2000 / AS9100 certified  
approuvé NADCAP approved

47556

08-May-2006

**CLIENT / CUSTOMER:****DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY, ONTARIO

K6A 1K7

**CERTIFICATE OF COMPLIANCE**  
**CERTIFICAT DE CONFORMITE****PURCHASE ORDER/** PO00001138  
**NO. DE COMMANDE:**

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	80	80	D103-858-B AVIONICS FASTENER RAIL	MATL: AL BLACK ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER

**REQUIREMENTS HAVE BEEN IN ACCORDANCE WITH MD-INC P.R.I.D.E. MANUAL**

06-05-07

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.  
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.  
Travel cards have been filed and are available for viewing upon request.

Signature/Signed:

  
TNM 48  
 Directeur de la Qualité / Q.A. Manager